

Split
Work Order ID 58350-1

Monday, May 23, 2010 3:14:31 PM



ASAP

Item ID: D3643-2

Revision ID:

Item Name: Stiffener

Start Date: 5/4/2010

Start Qty: *1* ~~10.00~~

Required Date: 5/6/2010

Req'd Qty: 10.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan: *MF*

Date: *10-5-3* Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3643

Rev A

100



Waterjet

FLOW WATER JET

0.00

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3643
Deburr if necessary

Dwg Rev: *1*

Prog Rev: *1*

2-

B10-5-3

16



110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

Quality Control

B10-5-3

120



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

Quality Control

8 w/lost

count
16

Order ID 58350



Monday, May 03, 2010 3:14:31 PM

Item ID: D3643-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Stiffener

Start Date: 5/4/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2010 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3643

0.00

0.00

Si 10/05/04 D

140



Small Fab

Small Fab

Small Fab

Memo

C'sink as per Dwg D3643

0.00

0.00

ES 10/05/04 @

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Si 10/05/04

@

Work Order ID 58350



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Item ID: D3643-2

Accept



Setup Start



Revision ID:

Stop



Item Name: Stiffener

Start Date: 5/4/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 5/6/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Handwritten initials

Handwritten: 10/05/04

Handwritten: 1

Handwritten: 0

Hand Finishing

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Handwritten: 0

Handwritten: BR 10-5-4.

Quality Control

180

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Handwritten: 10/05/04

Packaging

Handwritten signature

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Item ID: D3643-2

Revision ID:

Item Name: Stiffener

Start Date: 5/4/2010 Start Qty: 10.00

Required Date: 5/6/2010 Req'd Qty: 10.00

Reference:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/
Work Center ID

190



QC

Quality Control

Operation
Description

QC21- Final Inspection - Work Order Release

Memo

Set Up/
Run Hours

0.00

0.00

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

10/05/05

W 10/05/05

Print

May 03, 2010 3:14:30 PM

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Work Order ID: 58350



Parent Item: D3643-2

Parent Item Name: Stiffener

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC

Start Date: 5/4/2010

Required Date: 5/6/2010

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	506.7000	0.1475			
2024-T3 .040 sheet												



BLW-53

Location

Loc Qty

Loc Code

MAT		96	
	114415	96	
MAT22		410.7	
	110305	136.7	
	111786	18	
	112291	32	
	112331	64	
	113162	160	

111786

(21)

Ø0.098 THRU
C'SINK Ø0.179 X 100°
(4 PLACES)

Ø0.266 (2 PLACES)

BEND LINE

GRAIN
DIRECTION

1.90

1.36

0.96

1.25

0.344
(TYP)

2.000

4.49

9.00

9.75

0.81

1.16

R0.25 (TYP)

D3643-1F FLAT PATTERN
(D3643-2F OPPOSITE)

ENSURE THAT COUNTERSINKS
ARE ON THIS SIDE OF THE PART

0.60 (REF)

R0.13

1.41

D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)

RELEASED
07.09.07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

A	NEW ISSUE; REPLACES G10610	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DTI	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CE		
CHECKED	BE	DRAWING NO.	REV. A
MFG. APPR.	BE	D3643	SHEET 1 OF 1
APPROVED	BE	TITLE	SCALE
DE APPR.	BE	STIFFENER	2:3
DATE	07.07.27	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

